

Work Order ID 58845

Wednesday, May 19, 2010 1:39:34 PM

Page 1

Item ID: D3779-043

Revision ID:

Item Name: Handle Assembly (Interior)

Start Date: 5/19/2010 Start Qty: 3.00

Required Date: 5/26/2010 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: *H* Date: *10-5-19* Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3779	Rev A

100
Waterjet
FLOW CNC Waterjet
6061 . 175

FLOW WATER JET

Memo: *D3779-5*
1-Cut as per Dwg D3779 ☒ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

110
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

120
QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00

-0.00

0.00

0.00

S. 060601

Setup

Start

Stop

Run

Start

Stop

NOT PULLED

B10-5-07
B10-6-1

(4)

B10-5-07
B10-6-1

(4)

P10 →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3779-043 PAR #: _____ Fault Category: Small Fals NCR: Yes No DQA: _____ Date: 10/11/14
Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/17/14

NCR: <u>58845</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/15/14	4 100	During inspection found that water jet operator made the incorrect part D3779-3 were made should have been D3779-5.	<i>[Signature]</i>	→ SCRAP .125" parts because the are wrong thickness. + wrong parts. Redress with D3779-5	<i>[Signature]</i> 10-5-14	S 10/15/14	<i>[Signature]</i>	S 10/15/14
		R.C. operator went off Part sheet that was attached. Part sheet was wrong. w/o doesn't call for a Part on printing + employee thought	<i>[Signature]</i>	Part # 13424 Found out that w/o doesn't call for Part sheets. employee has to find the correct one in the system	N/A	S 10/15/14	<i>[Signature]</i>	S 10/15/14
		that a -043 needed a -3. - water jet operator made two sets of incorrect parts.	<i>[Signature]</i>	Issue w/o for D3779-3 scrapped above	N/A	N/A	<i>[Signature]</i>	S 10/15/14

NOTE: Date & initial all entries

Work Order ID 58845

Page 2

Wednesday, May 19, 2010 1:39:34 PM

Item ID: D3779-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Handle Assembly (Interior)

Start Date: 5/19/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00							
Small Fab	Memo 1- counter sink holes as per dwg D3779-2- deburr	0.00							
140 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

4510/06/03 (4)

8106603

(4)

= 7 m-h w/ 06/07

(4X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					1	
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58845

Wednesday, May 19, 2010 1:39:34 PM



Page 4

Item ID: D3779-043

Accept



Setup

Start



Revision ID:

Stop



Item Name: Handle Assembly (Interior)

Start Date: 5/19/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 3.00

Customer:

Reference:

Run

Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

5/19/06/23



QC

Memo

0.00

Quality Control

(XSC)

200

Identify as per dwg & Stock Location: *087*

0.00



Packaging

Memo

0.00

Packaging

5/19/06/27 (4)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 (4)

10/06/24 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, May 19, 2010 1:39:40 PM

Work Order ID: 58845

Parent Item: D3779-043

Parent Item Name: Handle Assembly (Interior)

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-21 procedure change DD verified by:EC

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS20426AD10-8

Purchased

No

100

Each

289.0000

4



Rivets

Location

Loc Qty

Loc Code

ST318

289

109681 ✓

239

110153

50

D3203-1

Manufactured

No

180

Each

6.0000

1



Handle

Location

Loc Qty

Loc Code

ST240

6

56366

6

M6061T6S.125

Purchased

No

180

sf

177.0500

0.4365

1.8



6061-T6 .125 Sheet

Location

Loc Qty

Loc Code

MAT21

177.05

112476

11

113424

6.05

113608

96

114352

64

110791

16x m-l 10/06/23

4 m-l 10/06/23

B10-5-27

113424 B10-6-1

110791

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-5-24		permanent change W					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

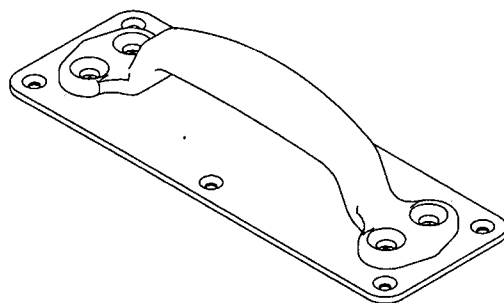
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

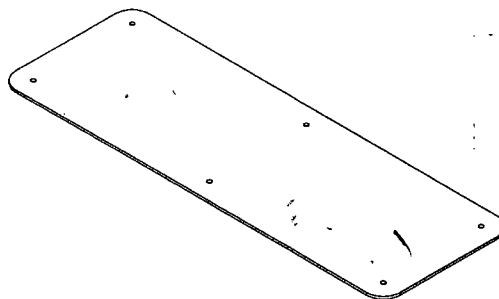
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58845

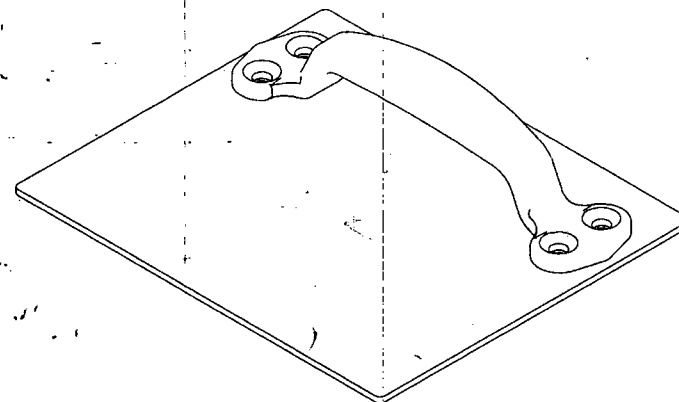
BJ-10-5-19



**D3779-041 HANDLE ASSEMBLY
(EXTERIOR)**



D3779-3 DOUBLER PLATE



**D3779-043 HANDLE ASSEMBLY
(INTERIOR)**

RELEASED
08-06-26 MJD

A		NEW ISSUE		AJS	08.04.21
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3779 TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR REV. A SHEET 1 OF 4 SCALE NTS	
DRAWN	AJS				
CHECKED	<i>[Signature]</i>				
MFG. APPR.	<i>[Signature]</i>				
APPROVED	<i>[Signature]</i>				
DE APPR.					
DATE	08.04.21			<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

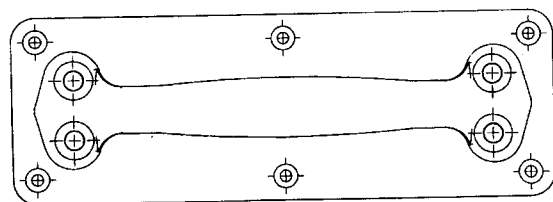
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

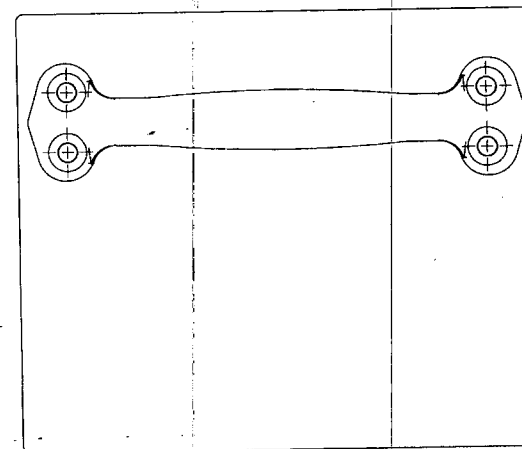
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

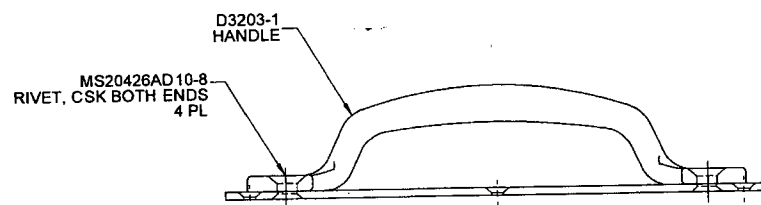
NOTE: Date & initial all entries



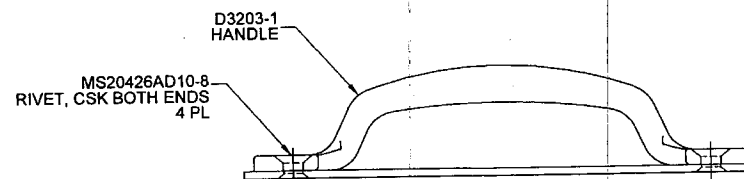
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

w/o 58845

RELEASED
08.06.26 1/08

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3779	REV. A SHEET 2 OF 4
MFG. APPR.		TITLE HANDLE ASSEMBLY, CABIN SLIDING DOOR	SCALE NTS
APPROVED		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DE APPR.		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.04.21		

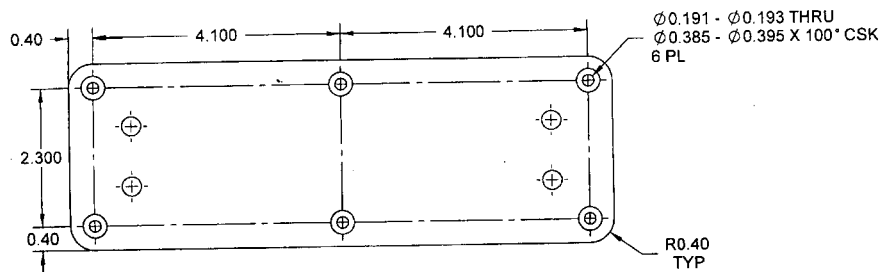
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

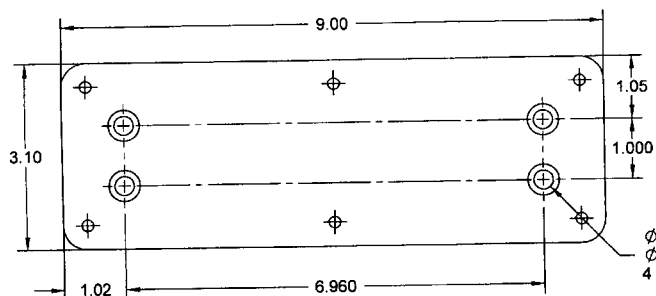


Ø0.191 - Ø0.193 THRU
Ø0.385 - Ø0.395 X 100° CSK
6 PL

R0.40
TYP

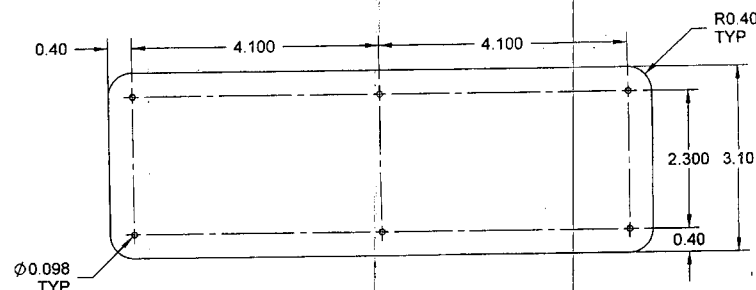


0.125
REF



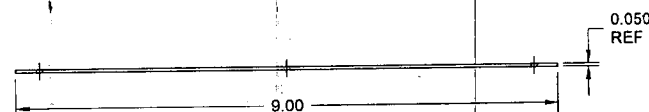
Ø0.316 - Ø0.322 THRU
Ø0.515 - Ø0.525 X 100° CSK
4 PL

D3779-1 PLATE



R0.40
TYP

Ø0.098
TYP



0.050
REF

D3779-3 PLATE

w/ 38845

NOTES:

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

**6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY -1 & -5)**

7) WEIGHT: 0.14 lbs FOR -3.

RELEASED
08.05.2010

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	HANDLE ASSEMBLY
DE APPR.		CABIN SLIDING DOOR	SCALE
DATE	08.04.21		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

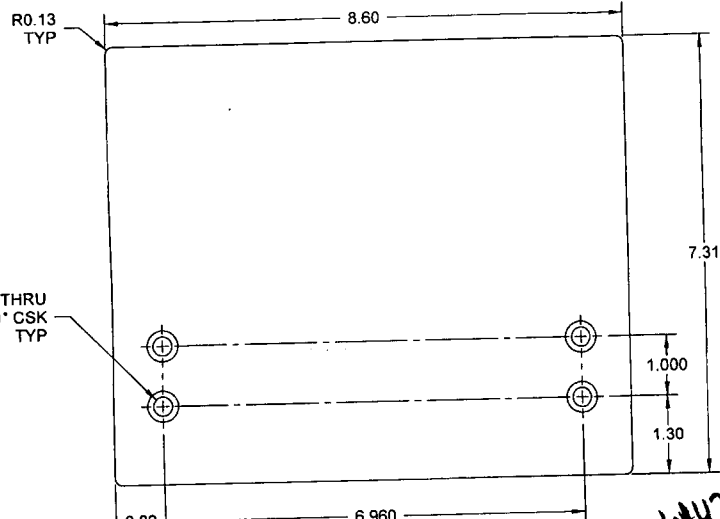
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ø0.316 - Ø0.322 THRU
Ø0.515 - Ø0.525 X 100° CSK
TYP



D3779-5 PLATE

NOTES:

- 1) MATERIAL: -5 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 4 OF
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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RELEASED
08-06-26

u/b 58845

7.276

1.442

0.662

1.178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries